

# Work Order ID 61871

Wednesday, September 08, 2010 1:34:18 PM



Page 1

Item ID: D4079-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half, Attachment

Stop



Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 10-9-08

Tooling:

Date:

QC:

Date:

SPC.(Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4079

B

100

0.00



Bandsaw

Jcaspa Bandsaw

Memo

Cut blank 2.750" long

0.00

*cut 10/09/26*

*12* *Ø*

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA931

Folio rev: *A*

Dwg Rev: *B*

0.00

*B.A 10/09/26*

*12* *Ø*

Deburr

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Item ID: D4079-1

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Setup Start



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Stop



Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 10/09/26

12

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

amk 10/09/27

12

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-9-28.

12

0



HandFinish

Memo

0.00

Hand Finishing

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Item ID: D4079-1

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Required Date: 9/13/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

10-9-29



Powdercoat

Powder Coating

M112588 START 10:35

Memo

0.00

OVERT. 3200

FINISH 11:05

12

φ

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

⇒ M1 10/09/29

12

φ

170

Identify as per dwg &amp; Stock Location: 123

0.00



Packaging

Packaging

Memo

0.00

10/19/29 sf

12x

**Work Order ID 61871**

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Page 4

Item ID: D4079-1

Accept

Revision ID:

Item Name: Clamp Half, Attachment

Start Date: 9/8/2010 Start Qty: 12.00

Required Date: 9/13/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30  
MF  
10-9-29

# Picklist Print

Wednesday, September 08, 2010 1:34:21 PM

Page 1

Work Order ID: 61871

Parent Item: D4079-1

Parent Item Name: Clamp Half, Attachment



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10\*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	41.5135	0.23	2.905263			



6061-T6 Bar 2.00 x 2.00



Location

MAT09

→ 113006

113123

13085

Loc Qty

41.5135

20

12.5135

9

Loc Code

2.905 *mk 10/09/26*

DART AEROSPACE LTD		Work Order: 61871
Description: CLAMP HALF, ATTACHMENT		Part Number: D4079-1
Inspection Dwg: D4079 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

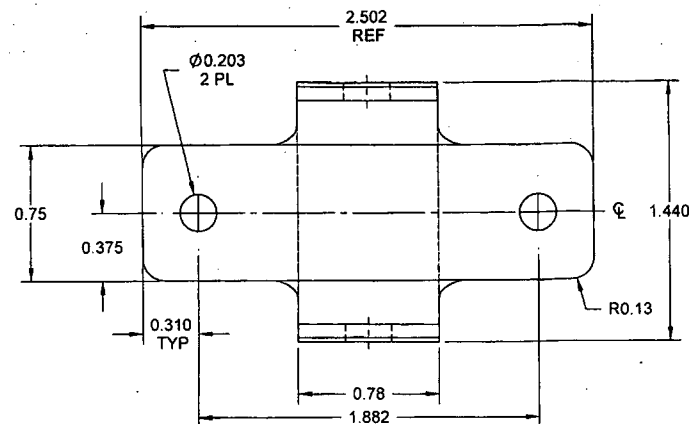
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/- .010	2.505	✓		Vern	GA-01
Ø 0.203	+ .005 / - .001	Ø 0.205	✓		"	"
0.75	+/- .030	0.747	✓		"	"
0.375	+/- .010	0.375	✓		"	"
0.310	+/- .010	0.309	✓		"	"
1.882	+/- .010	1.882	✓		"	"
0.78	+/- .030	0.781	✓		"	"
R0.13	+/- .030	R0.125	✓		Rad gage	ref
1.440	+/- .010	1.438	✓		Vern	GA-01
R0.38	+ .010 / - 0.000	R0.380	✓		Rad gage	ref
R0.050	+/- .010	R0.050	✓		"	"
R0.73	+/- .030	R0.730	✓		"	"
Ø 0.257	+ .006 / - .001	Ø .258	✓		Vern	GA-01
R0.25	+/- .030	R0.250	✓		Rad GAGE	ref
0.390	+/- .010	0.390	✓		Vern	GA-01
0.850	+/- .010	0.852	✓		"	"
0.025 x 45°	+/- .010	0.025 x 45°	✓		"	"
0.100	+/- .010	0.099	✓		"	"
R0.05	+/- .030	R0.063	✓		Rad Gage	ref.
1.240	+/- .010	1.239	✓		Vern	GA-01
1.65	+/- .030	1.654	✓		Height gage	31006
0.60	+/- .030	0.599	✓		"	"
0.23	+/- .030	0.228	✓		Vern	GA-01

Measured by: H.A	Audited by: <i>[Signature]</i>	Preliminary Approval: <i>[Signature]</i>
Date: 10/09/26	Date: 10/09/27	Date: 11/14

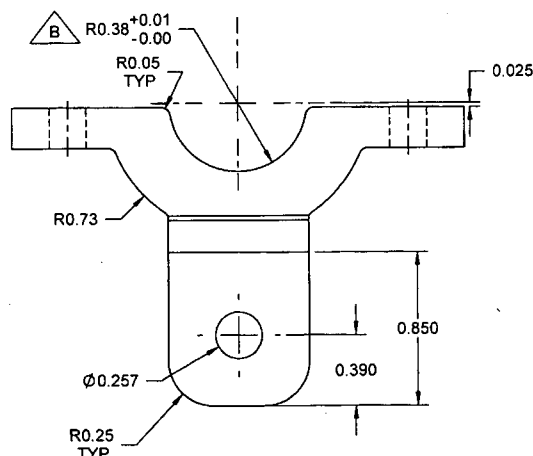
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Signature]* 10.04.15





GRAIN  
DIRECTION

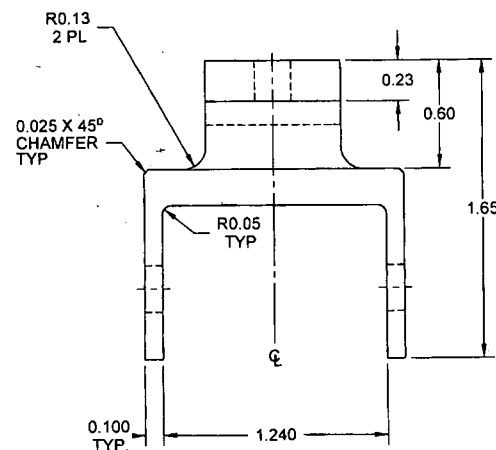
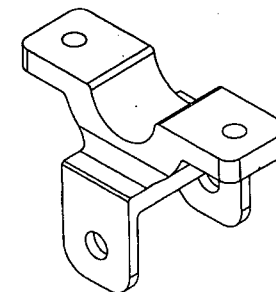


**D4079-1 CLAMP HALF, ATTACHMENT**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO REVISION  
WITHOUT NOTICE  
WORK ORDER NO. *C1871*  
*AS10-9-08*



**RELEASED**  
2010-09-07

B	R0.38 WAS R0.48.		10.07.30
A	NEW ISSUE		10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4079</b>	REV. B SHEET 1 OF 1
TITLE <b>CLAMP HALF, ATTACHMENT</b>	SCALE NTS
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